

Work Order ID 79358

Wednesday, January 25, 2012 12:25:30 PM

79358

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Item ID: D3214-1

Revision ID:

Item Name: Placard

Start Date: 1/25/2012 Start Qty: 8.00

Required Date: 2/3/2012 Req'd Qty: 8.00

Reference:

Approvals:

Process Plan: M.L.S

Date: 12/01/25 Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

NR1

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3214	Rev B

100

0.00

100

Shear

Shear

SHEAR

Memo

Cut blanks: 3.70" x 2.70" Drill hole and fillet corner as per Dwg
D3214DeburIdentify as D3214-1

0.00

SB 8 FF 12-02-14

110

QC5- Inspect part completeness to step on W/O

0.00

110

QC

Quality Control

Memo

0.00

Sizably

(FE)

120

Chemical Conversion Coat per QSI005 4.1

0.00

120

HandFinish

Hand Finishing

Memo

0.00

8x8 M/L 12/02/15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID: D3214-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Placard
 Start Date: 1/25/2012 Start Qty: 8.00 ***8*** Cust Item ID:
 Required Date: 2/3/2012 Req'd Qty: 8.00 ***8*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Black Sandtex(Ref:4.3.5.7) per QSI005 4.3	0.00							
130									
Powdercoat									
Powder Coating									
<i>m115128</i>	Memo								
	START TIME: <i>3:30</i>	0.00							
	FINISH TIME: <i>4:00</i>								
	<i>3200F</i>								
140	QC3- Inspect Part Finish	0.00							
140									
QC									
Quality Control	Memo								
150		0.00							
150									
HAAS 1	Small Fab								
HAAS CNC vertical machine #1	Memo	0.00							
	Engrave text as per Folio FA394 and Dwg D3214								

8x4 m/l 12/02/15

8 BL 12-2-15

R2 12.2.21

8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Wednesday, January 25, 2012 12:25:30 PM

Item ID: D3214-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Placard
 Start Date: 1/25/2012 Start Qty: 8.00 ***8*** Cust Item ID:
 Required Date: 2/3/2012 Req'd Qty: 8.00 ***8*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 *160* QC Quality Control	QC2- Inspect parts off machine FAI/FAIB Memo	0.00 0.00		RE 12. 2. 21		8			
180 *180* Packaging Packaging	Identify as per dwg & Stock Location: <u>202</u> Memo	0.00 0.00							12/2/21 (80)
190 *190* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							12/2/22 (8)

12-22-22 (8)

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

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Work Order ID: 79358

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Parent Item: D3214-1

D3214-1

Parent Item Name: Placard

Start Date: 1/25/2012

Required Date: 2/3/2012

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP A04.04.15New issueKJ/RF
IPP Rev:B Now 6061-T6 06-06-23 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.080		Purchased		No		110	sf	390.3000	0.0743	0.625684			
									**	8	FF	12-02-14	

M6061T6S 080

6061-T6 .080 Sheet

Location

Loc Qty

Loc Code

MAT021

390.3

117285

7.3

119009

3.5

119766

187.5

120349

192

0.625

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DART

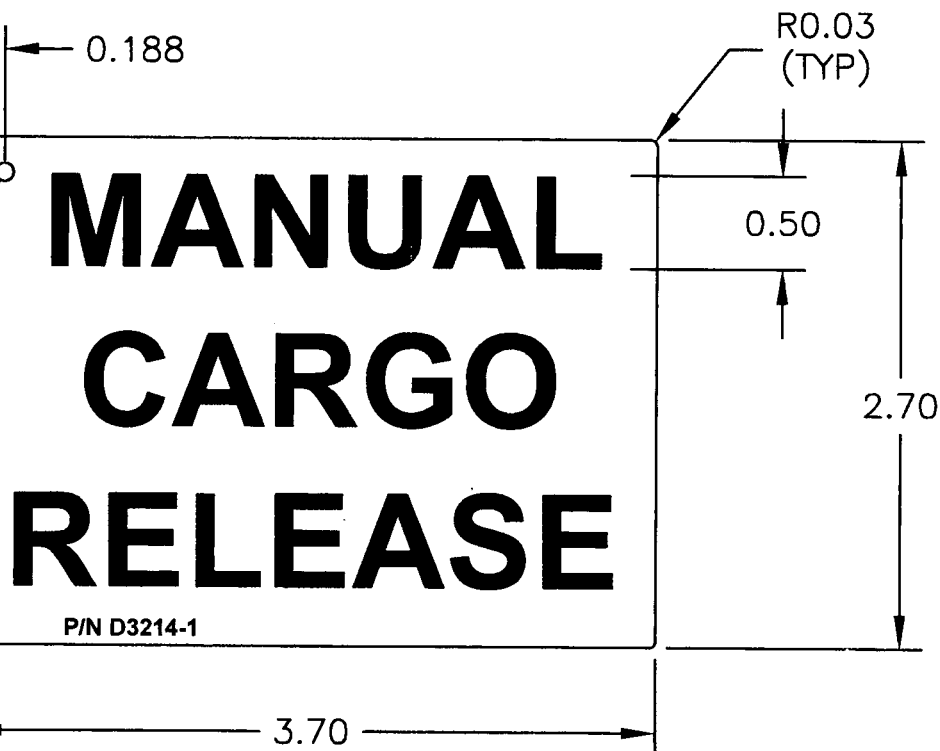
DESIGN F#	DRAWN BY C.B.	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED PH	APPROVED [Signature]	DRAWING NO. D3214	REV. B SHEET 1 OF 1
DATE 06.05.29	TITLE PLACARD		SCALE 1:1
A	04.01.27	NEW ISSUE	
B	06.05.29	ADD 6061-T6 MATERIAL	

RELEASED

06-06-20 [Signature]

SEAL COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITH NOTICE
WORK ORDER
NO. 79358 M.C.J.

12/01/25

**D3214-1****NOTES**

- 1) MATERIAL: 6061-T6 (PER QQ-A-250/11 OR AMS 4025 OR AMS 4027) 0.080" THICK (REF DART SPEC M6061T6S.080) OR 5052-H32/H34 (PER QQ-A-250/8 OR AMS 4016) 0.080" THICK (REF DART SPEC M5052H32S.080)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT BLACK SANDTEX (REF. 4.3.5.7) PER DART QSI 005 4.3
- 3) ENGRAVE LETTERS (0.50" HEIGHT) AS SHOWN AFTER POWDER COAT
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

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